

Date: Wednesday, 15/08/2007 4:07:19 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
Jot Number : 33967
Estimate Number : 12712
P.C. Number : N/A Part Number : D35371
This Issue : 15/08/2007 S.O. No. : N/A Drawing Number : D3537 REV C
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB Drawing Revision : C
Previous Run : 33660 Material : N/A Due Date : 01/09/2007 Qty: 101 Um: Each
Written By : JLM 07-08-16.
Checked & Approved By :
Comment : Est Rev: A New Issue 07-02-14 JLM

Additional Product

Jot Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0788 sf(s)/Unit Total: 7.8750 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: M105130

SAD 07/08/17

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

SAD 07/08/17

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/17

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 07/08/22 (4101)

counter

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

SB 07/08/22 (101)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/06
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:07:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33967

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

M105738 / M105315

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

FC 07/08/29

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107/08/30 (101)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/08/30 (101)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M104846

M-k 07/09/05

(101X)

10.0

QC9

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ed 07/09/05 (102)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 18

M-k 07/09/05

(10K)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107/09/06 (10)

Job Completion



U 07-09-06

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

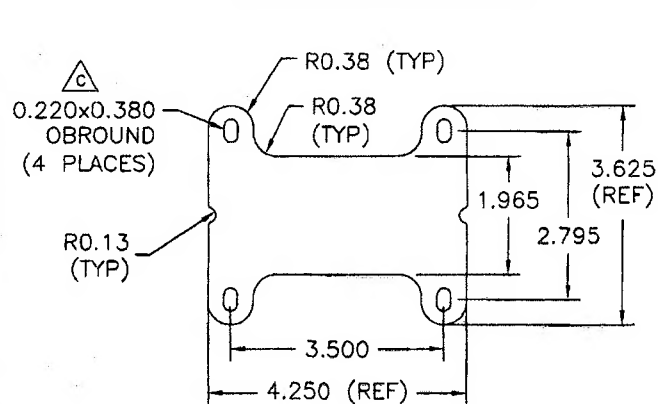
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

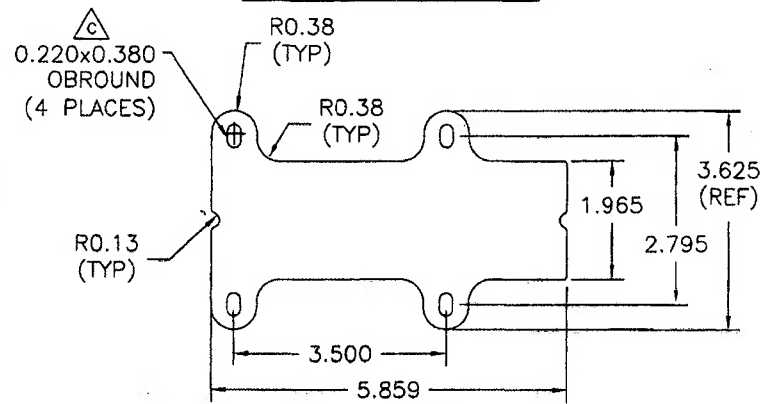
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

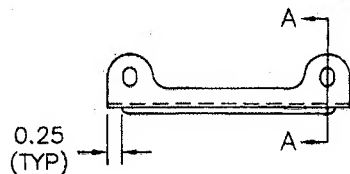
D3537-1F FLAT PATTERN



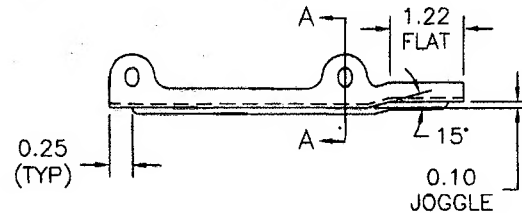
D3537-3F FLAT PATTERN



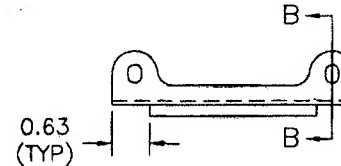
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



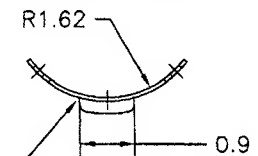
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

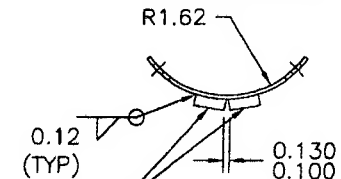
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



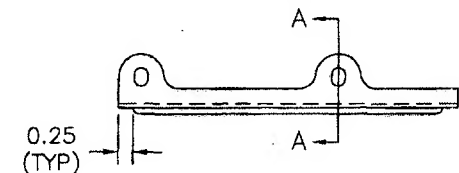
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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|---------|----------|--|
| C | 07.04.13 | WIDEN TAB TO 0.380, WELD PATTERN |
| B | 07.03.20 | ADD AMS 5513 AND AMS 5524 |
| A | 06.11.06 | NEW ISSUE |
| DESIGN | CB | DRAWN BY PH |
| CHECKED | A | APPROVED A |
| DATE | 07.04.13 | TITLE WEARPAD |
| | | DART AEROSPACE USA, INC. PORT HADLOCK, MA |
| | | DRAWING NO. D3537 |
| | | REV. C |
| | | SHEET 1 OF 1 |
| | | SCALE 1:2 |

RELEASED
07.05.08 PH
per ELN
952